

86335

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N900040100

Setup Start ***NS1***

Stop *NS2*

Start Date: 6/27/12 **Start Qty:** 2.00 ***2***

Cust Item ID:

Required Date: 6/27/12 **Req'd Qty:** 2.00 ***2***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3889	A

100

0.00

100

Waterjet

FLOW CNC Waterjet

Memo

0.00

1-Cut as per Dwg D3889-1

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Quality Control

Memo

0.00

B12-6-57

B(2-6-8)

86335

June-27-12 1:30:29 PM

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 6/27/12 **Start Qty:** 2.00 ***2***

Cust Item ID:

Required Date: 6/27/12 **Req'd Qty:** 2.00 ***?***

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Operation Description

Set Up/ Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120

QC8- Inspect parts - second check

0.00

120

Solved

0.00

QC

Memo

Quality Control

130

0.00

130

~~0.00~~

Small Fab

Memo

Deburr ~~if necessary~~

Small Fab

140

Pick Kit

0.00

140

0.00

Packaging

Memo

Packaging

86335

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N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 6/27/12 **Start Qty:** 2.00 ***2***

Cust Item ID:

Required Date: 6/27/12 **Req'd Qty:** 2.00 ***2***

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150

0.00

150

0.00

Small Fab

Memo

0.00

Small Fab

1- Bond gasket to smooth side of panel as per dwg
A/R 3M 1300 adhesive Batch: 120904

A/R 3M 1300 adhesive Batch: 120904

0.00

160

160

0.00

QC

Memo

Quality Control

QC5- Inspect part completeness to step on W/O

Identify as per dwg & Stock Location:_____

0.00

170

170

0.00

Packaging

Memo

Packaging

Work Order ID 86335***86335***

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June-27-12 1:30:29 PM

Item ID: D3889-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Panel, Floor
Start Date: 6/27/12 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 6/27/12 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

12/6/28
MF
12-06-27

Picklist Print

June-27-12 1:30:28 PM

Page 1

Work Order ID: 86335

Parent Item: D3889-041

Parent Item Name: Panel, Floor

Start Date: 6/27/12

Required Date: 6/27/12

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.125-F60029-04 GE PLASTICS LEXAN SHEET		Purchased	No			100	sf	1,654.1064	8.1925	17.247368	18.		

1812-6-27

				<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
				MAT018	1503	
				121803	1503	
				MAT019	151.1064	
				119937	151.1064	

D3889-3 Gasket		Manufactured	No			140	Each	3.0000	1	2			
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119937

(2)

(2)

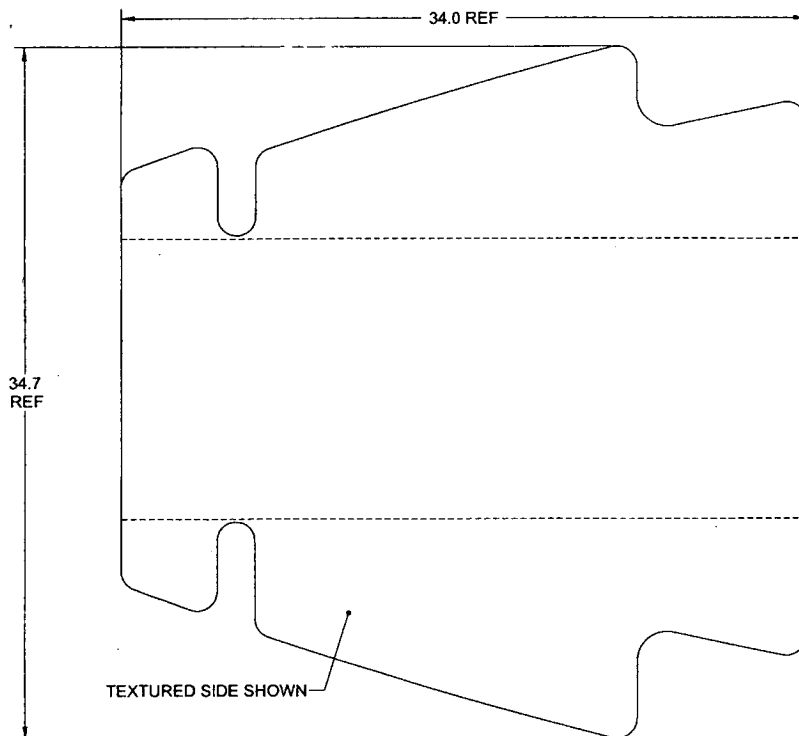
FF 12-06-27

				<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
				ST	2	
				77555	2	
				ST242	1	
				81017	1	

2

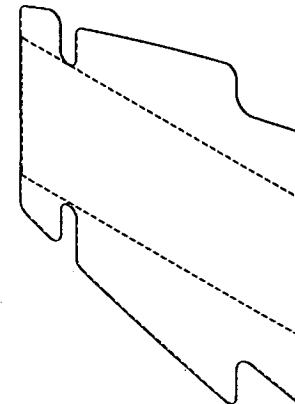
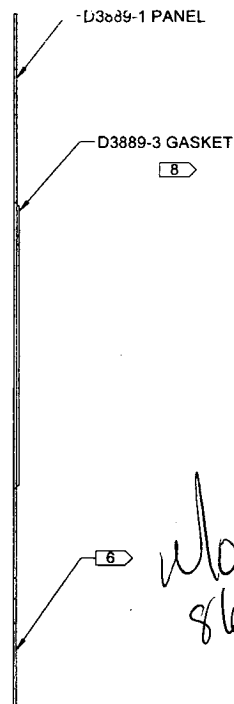
PARTS LIST

ITEM	QTY	P/N	DESCRIPTION
1	X	D3889-041	PANEL, FLOOR
2	1	D3889-1	PANEL
3	1	D3889-3	GASKET
4	A/R	3M 1300	ADHESIVE

**D3889-041 PANEL, FLOOR**

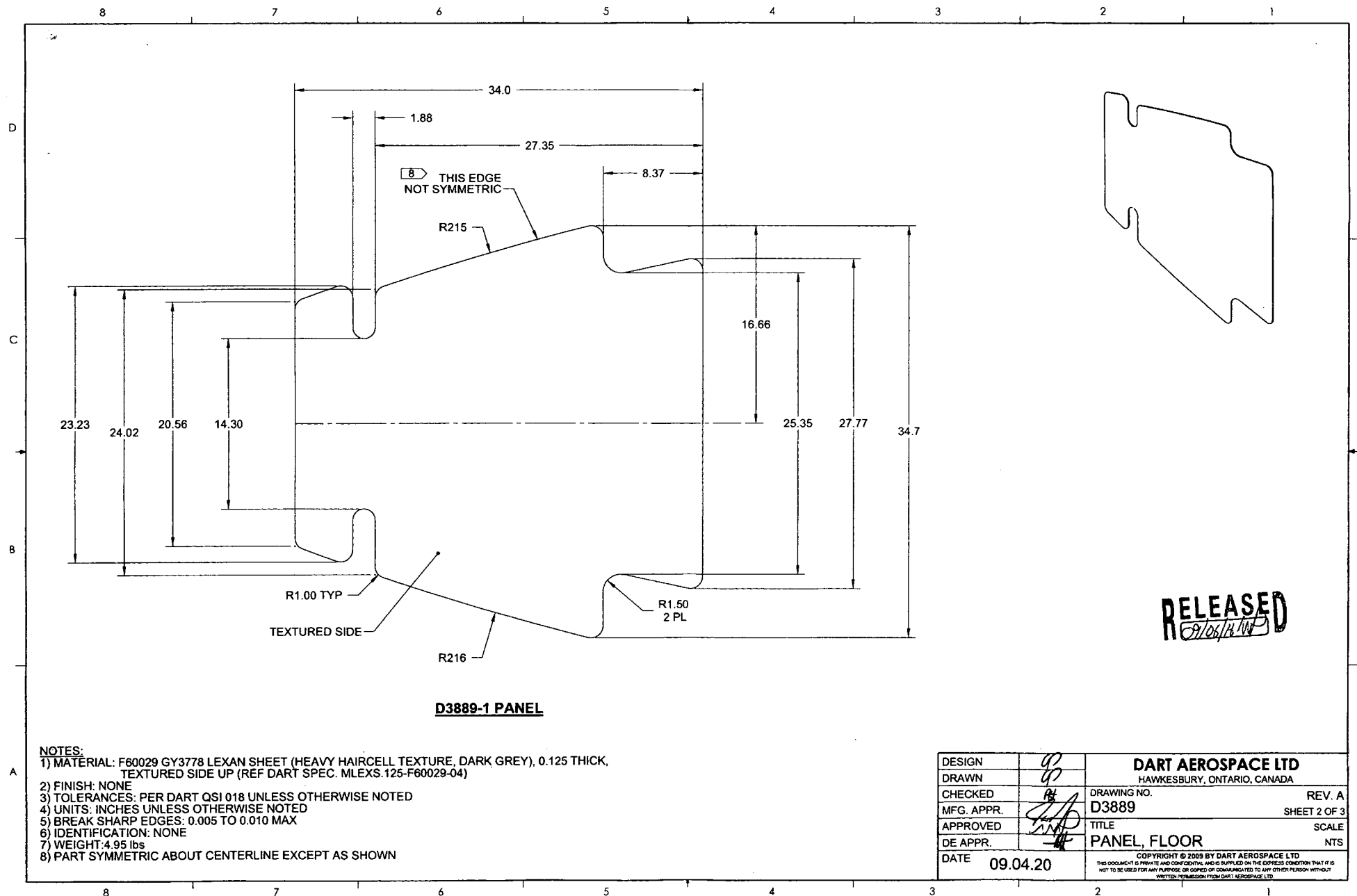
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3889-041" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH/UNTEXTURED SIDE OF PART
- 7) WEIGHT: 5.13 lbs
- 8) BOND GASKET TO SMOOTH/UNTEXTURED SIDE OF PART USING 3M 1300 ADHESIVE. TRIM GASKET TO EDGES OF PANEL, IF REQUIRED.

**RELEASED**
09/28/16 NLP

A	NEW ISSUE	CP	09.04.20
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.04.20		






DART AEROSPACE LTD		REV. A
HAWKESBURY, ONTARIO, CANADA		SHEET 1 OF 3
DRAWING NO. D3889		SCALE
TITLE PANEL, FLOOR		NTS
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D3889-3 GASKET

NOTES:

- 1) MATERIAL: NEOPRENE FOAM SHEET, 0.125 THICK
(REF DART SPEC. M4111N-S.125)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.19 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3889	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		PANEL, FLOOR	NTS
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